



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9347	REV. A SHEET 1 OF 1
DATE 06.08.23		TITLE STEP ARM WELD REPAIR	SCALE NTS
A	06.08.23	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-630 REV 0 OR 1

REF. CANADIAN STC: SH96-69

REF. FAA STC SR00595NY / SR00597NY / SR00598NY

CRACKS UP TO 0.375" IN LENGTH IN SHADED REGION OF D2801-041/-042, D2812-041/-042 AND D3388-041/-042 STEP WELDMENTS (SEE FIGURE 1 BELOW) CAN BE REPAIRED AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC.
- 2) GRIND A CHAMFER 0.125" X 45° ALONG THE CRACK.
- 3) T.I.G. WELD CHAMFER PER MIL-STD-2219 / AMS-STD-2219 CLASS 'C' USING 4043 OR 5356 FILLER ROD.
- 4) BLEND WELD TO SAME PROFILE AS ORIGINAL PART.
- 5) LIQUID PENETRANT INSPECT PER ASTM 1417 LEVEL 2 (MINIMUM). NO CRACKS OR POROSITY INDICATORS ALLOWED.
- 6) TOUCH UP FINISH IN ACCORDANCE WITH ICA-D412-630 REV 0 OR 1.

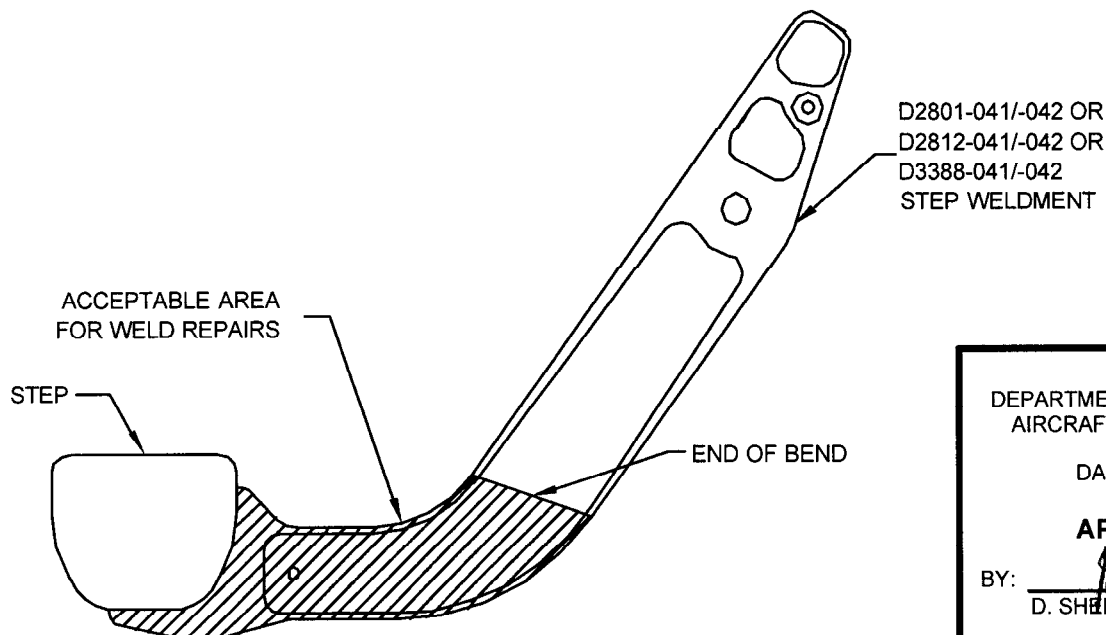


FIGURE 1. ACCEPTABLE AREA FOR WELD REPAIRS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
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